

**Work Order ID 67727**

Tuesday, March 29, 2011 2:28:05 PM



Page 1

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: HDate: 11-03-30Tooling: Date: 

Run Start

QC: Date: SPC (Y/N): Date: 

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2024.063

F  
EB11-4-67

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Suloy10647

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67727**

Tuesday, March 29, 2011 2:28:05 PM



Page 2

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges □2-Countersink holes per Dwg D2344

EP 11/04/15 (7)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

nl 11 04 15 (9)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

7 6 20 4/04/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




**Work Order ID 67727**

Page 3

Tuesday, March 29, 2011 2:28:05 PM

Item ID: D2344 Accept  Setup Start   
Revision ID:  
Item Name: Litter Deck Plate, 350 Stop   
Start Date: 3/29/2011 Start Qty: 6.00  Cust Item ID:  
Required Date: 4/8/2011 Req'd Qty: 6.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: <u>8:30</u> <u>9:00</u> FINISH TIME: <u>3:20</u>	0.00 0.00				<u>11</u>	<u>04</u>	<u>19</u>	<u>3</u>
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<u>7</u>	<u>0</u>	<u>11/04/19</u>	
180  Packaging Packaging	Identify as per dwg & Stock Location <u>St-224</u>  Memo	0.00 0.00				<u>7</u>	<u>JB</u>	<u>11/04/19</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67727**

Page 4

Tuesday, March 29, 2011 2:28:05 PM

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 3/29/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/2011

MF 11-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, March 29, 2011 2:28:20 PM

Page 1

Work Order ID: 67727

Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350



Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D000.06.26 Removed P/O for powder coat EC  
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

57.0000

0.745

4.705263



1811-4-6

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

57

113867

5

114351

4

117018

48

114351

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	67727
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2344
<b>Inspection Dwg:</b> D2344	<b>Rev:</b> F	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.221	X		V 1802	
5.598	+/-0.010	5.597	X		V	
4.869	+/-0.010	4.870	X		V	
3.889	+/-0.010	3.887	X		V	
3.096	+/-0.010	3.096	X		V	
2.891	+/-0.010	2.893	X		V	
16.973	+/-0.010	16.973	X		T 1801	
0.450	+/-0.010	0.449	X		V	
4.423	+/-0.010	4.422	X		V	
4.723	+/-0.010	4.722	X		V	
1.202	+/-0.010	1.200	X		V	
5.869	+/-0.010	5.869	X		V	
4.654	+/-0.010	4.656	X		V	
Ø0.656	+0.005/-0.000	0.656	X		V	
1.888	+/-0.010	1.882	X		V	
2.285	+/-0.010	2.283	X		V	
2.683	+/-0.010	2.681	X		V	
Ø0.171	+0.005/-0.000	0.172	X		V	
3.491	+/-0.010	3.490	X		V	
Ø0.191	+0.005/-0.000	0.191	X		V	
3.123	+/-0.010	3.123	X		V	
1.975	+/-0.010	1.970	X		V	
Ø0.128	+0.005/-0.001	0.129	X		V	

<b>Measured by:</b>	RB	<b>Audited by:</b>	8	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11-4-6	<b>Date:</b>	11/04/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE





